Work	Order	ID	61951
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Monday, September 13, 2010, 8:21:23 AM



Page 1

Item ID:

D412-711-101

Accept

Setup Start



Revision ID:

Item Name: Replacement Bubble Window

**Start Date:** 

9/13/2010

Start Oty: 1.00

Req'd Oty: 1.00

**Cust Item ID: Customer:** 

Reference:

Approvals:

**Required Date: 9/20/2010** 

**Process Plan:** 

Date: 10913 Tooling:

Date:

Date:

Run

Start Stop

Stop



OC:

Date:

SPC (Y/N):

Tool # Plan Accept

Reject

Reject

Insp.

Work Center ID Draw Nbr

Sequence ID/

Operation Description

**Revision Nbr** 

Set Up/

**Run Hours** 

Tool ID

Qty Code

Qty

Number

Stamp

D412-711-101 Α

100

Document Control

Memo

Photocopy bluefiles and create labels for PPP D412-711-101 Change 002 0.00

0.00

5 10/09/23

110

HandThermo

HAND FINISHING THERMOFORMING

Memo

0.00

0.00

Hand Finishing Thermoforming

Set up Machine as per folio FTA 077 and D711W program

La 10/00/20

120

HandThermo

HAND FINISHING THERMOFORMING

Memo

0.00

0.00

Hand Finishing Thermoforming

Cut Blanks to 36" by 39"

W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvat QC Inspector	
									, roung,		
Part No		PAR #:	Fault Cate	gory:	_ NCR:						
	R	esolution:	Dispositio	n:	_ QA: 1	V/C Clos	sed:		Date:		
NCR:		1	WORK ORD	ER NON-CONFORMA	ANCE	(NCR)					
DATE	STEP	Description of NC Corrective Action Section				Verifica			Approval		
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	С	Chief Eng	QC Inspector	
							i.				

#### Work Order ID 61951

Monday, September 13, 2010 8:21:23 AM



Page 2

Insp.

Stamp

Item ID: D412-711-101 Accept Setup Start **Revision ID:** Stop Replacement Bubble Window Item Name: Start Qty: 1.00 **Start Date:** 9/13/2010 **Cust Item ID:** Req'd Qty: 1.00 **Required Date: 9/20/2010 Customer:** Reference: Start Run Process Plan: Date: \_\_\_\_\_ Approvals: Tooling: Date: \_\_\_\_\_ Stop Date: SPC (Y/N): QC: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Work Center ID Description Code Qty **Run Hours Qty** Number 130 0.00 THERMOFORMING MACHINE Thermoform 0.00 Memo Thermoforming Machine Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA 077 Dwg. Rev. Folio Rev. 140 QC2- Inspect parts off machine FAI/FAIB 0.00 ×1 10/39/20 OC 0.00 Memo Quality Control 1) Check Surface finish for undesired marks, voids, dimples etc. □2) Check depth of bubble to ensure conformity to drawing tolerances.

150

QC

**Quality Control** 

QC8- Inspect parts - second check

0.00

Memo

0.00

B (X1) 10/07/20

W/O:		WORK ORDER CHANGES							
DATE	STEP	PRC	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approvat QC Inspector	
Part No	•	PAR #:	Fault Cat	tegory:	NCR: Yes	Date: _	····		
Resolution: Disposit				ion:	QA: N/C CI	osed:	Date: _		
NCR:		`	NORK ORI	DER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section	on B Sign 8	- Verification		Approval	
		Section A	Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector	
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								1	

#### Work Order ID 61951

Monday, September 13, 2010 8:21:23 AM



Page 3

Item ID: Revision ID: Item Name: Start Date:

D412-711-101

Replacement Bubble Window

9/13/2010 **Required Date: 9/20/2010** 

Start Otv: 1.00 Req'd Otv: 1.00

Accept



Run

Accept

Oty

Setup Start



Reference:

Approvals:

Process Plan:

Date: Date:

Tooling: SPC (Y/N):

Set Up/

Date: Date:

**Cust Item ID:** 

**Customer:** 

Tool ID

Tool # Plan

Code

Start Stop

Reject

Number

Insp.

Stamp

Sequence ID/

Work Center ID

160

HandThermo

Hand Finishing Thermoforming

Operation Description

**Run Hours** 

0.00

0.00

HAND FINISHING THERMOFORMING

Memo

1) Trim off excess flange material blemishes

2) Buff out any light scratches or 3) Etch part number and batch number

Reiect

Oty

170

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

1) VIsually inspect for clarity, and proper formation.

180

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

1) VIsually inspect for clarity, and proper formation.

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRC	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								r rod wigi			
							i				
Part No	:	PAR #:	Fault Cat	tegory:	NCR: Yes No DQA: Date:						
					QA: N/C Closed: Date:						
NCR:			WORK ORI	DER NON-CONFORMA	NCE (NCR	)			·		
DATE	STEP	Description of NC			on B	Verification			Approval		
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Approval Chief Eng	QC Inspector		
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·											
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#### Work Order ID 61951

Monday, September 13, 2010 8:21:23 AM



Page 4

Item ID:

D412-711-101

Accept

Setup Start

Stop

**Revision ID:** 

Item Name: Replacement Bubble Window

**Start Date:** 9/13/2010 Start Qty: 1.00

Required Date: 9/20/2010

Req'd Qty: 1.00



**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Set Up/

Date:

Tool ID

Date:

Stop



Sequence ID/

Work Center ID

185

190

Packaging

Packaging

Quality Control

Operation Description

QC:

QC4- 100% Inspect kits for completeness

Date:

0.00 0.00

**Run Hours** 

D Woorles

Tool # Plan Accept Code **Qty** 

Reject **Qty** 

Run

Reject Number Stamp

Insp.

Identify as per dwg & Stock Location:

Memo

Memo

0.00

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/09/2798 MF 10-9-24

Memo

W/O:		WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CHAN		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval- QC Inspector
Part No		PAR #:	Fault Categ	_ NCR: Yes	NCR: Yes No DQA: _				
Resolution:			Disposition	_ QA: N/C Cld	sed:		Date: _		
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR	)			
DATE	STEP	Description of NC	ption of NC Corrective Action			Verific	ation	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
					i				
····						1			

#### **Picklist Print**

Monday, September 13, 2010 8:21:29 AM

Work Order ID: 61951

Parent Item:

D412-711-101

Parent Item Name: Replacement Bubble Window



**Start Date:** 9/13/2010

Required Date: 9/20/2010

Page 1

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP Rev:A New Issue 06-02-01

Manufacture in-house 10/06/28 DL

JLM IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236		Purchased	No				sf	113.0000	16	16			

Plexiglass G .236"

<b>Location</b>	Loc Oty	Loc Code
therm	113	
113571	17	
115096	16	
115590	80	

20.54 At. 10/09/24 Wes

W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng /	Approval- QC Inspector		
N-10-PV-Re-Societ Number		THU CALL					Prod Mgr	a a moposio.		
	a a									
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date: _					
	R	esolution:	Dispositio	n:	QA: N/C CI	osed:	Date: _			
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCF	1)	-			
DATE	0750	Description of NC			ction B	Verification	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspector		

DART AEROSPACE LTD	Work Order:	61451
Description:	Part Number:	712-711-101
Inspection Dwg: D412-711-10   Rev:		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

#### THERMOFORMING SECTION

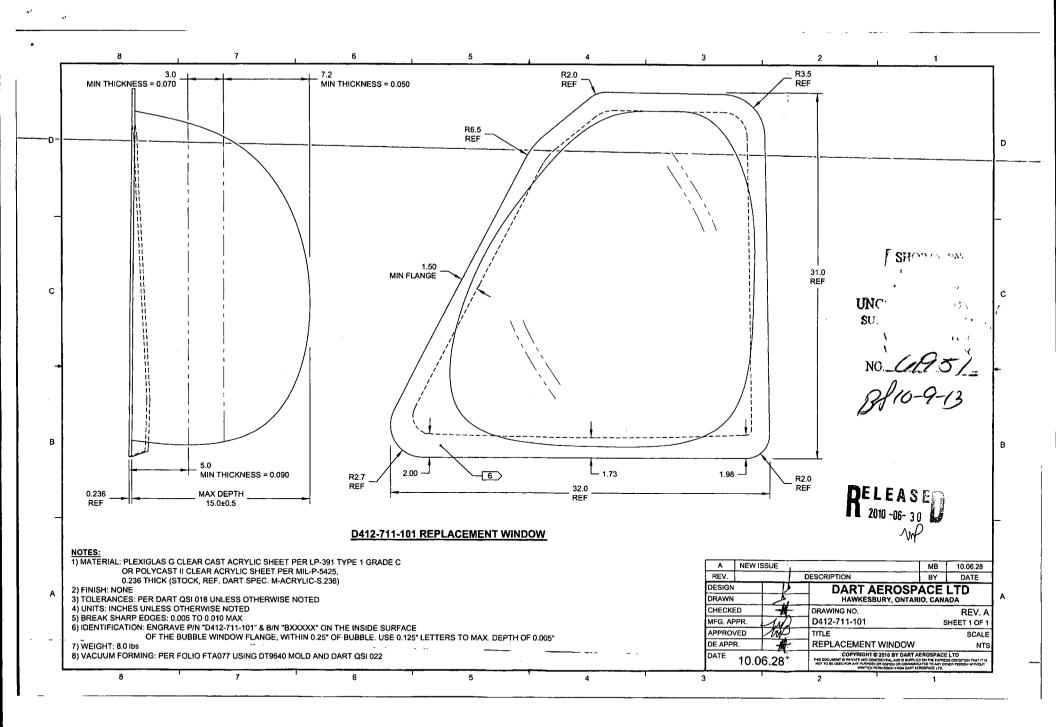
Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than"				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				
Measured by:	}		Date:	10/09/20

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.6"	7-0,030	1.034	<i>w</i>			
1.73"	4-0,030	176"	/			
1.984	4-0,030	2.00"				
1.504	1/0050	153"				
0.090"	Min	0.1014	<b>~</b>			
10 070°	MIN	0,101"	<u> </u>			
0.050"	MIN.	0.0801				
-						

Measured by:	Date: 10/09/31
Audited by:	Date: 10/29/2/
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
В	10.04.14	Added preliminary approval	KJ	



W/O:			WC	ORK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE			Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval • QC Inspector
Part No:		PAR #:	Fault Cate	_ NCR: Ye	NCR: Yes No DQA: Date:					
	Re	esolution:	Dispositio	_ QA: N/C	QA: N/C Closed: Da					
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Verificat				Approval
			Initial Chief Eng	Action Description Chief Eng		n & ite	Section C		Chief Eng	QC Inspector
						-				